

Work Order ID 61502

Page 1

Friday, August 27, 2010 3:28:06 PM

Item ID: D3535-33

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/30/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-8-27 Tooling:

Date:

Run Start



QC:

Date: _____ SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3535	Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

B 10-9-8

FLOW CNC Waterjet

304 - 040I-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

(B)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B 10-9-8

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

10/09/09

(W)

P10 →

Quality Control

W/O: 61502		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/09/02	# D0	Took Qty +1 for QC inspection template	S	10/09/02	x1		S 10/09/02

Part No: D3535-33 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

(13)

Brake NC

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326. 2-
Identify as D3535-33.

SB 10/09/09

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

S.使者

(13)

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

bh 10-9-10

Powdercoat

Powder Coating

Memo

0.00

START TIME: 10:20 OVEN TEMPERATURE:
320 FINISH TIME: 10:50

(13)

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

M 10/09/13

13

170



Packaging

Packaging

Identify as per dwg & Stock Location:

IP-19 0.00 BR 10-9-13

13

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/14 JJ

10-9-13

(13)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, August 27, 2010 3:28:06 PM

Page 1

Work Order ID: 61502



Parent Item: D3535-33



Parent Item Name: Wearshoe

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	118.2987	0.6445	8.141053	 8.141053 B10-9-8		

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT	16.1522	
114574	16.1522	
MAT20	102.1465	
112885	2.7475	
113062	0.699	
115440	98.7	115440

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	61802
Description: Wearshoe	Part Number:	D3535-33
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

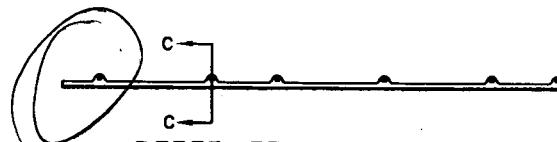
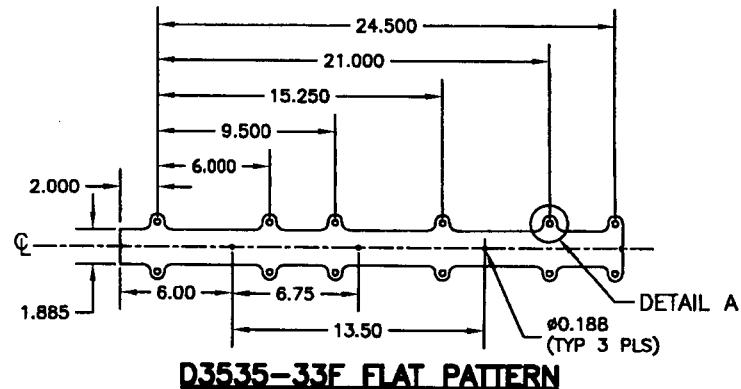
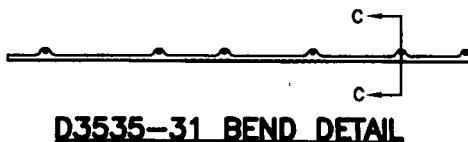
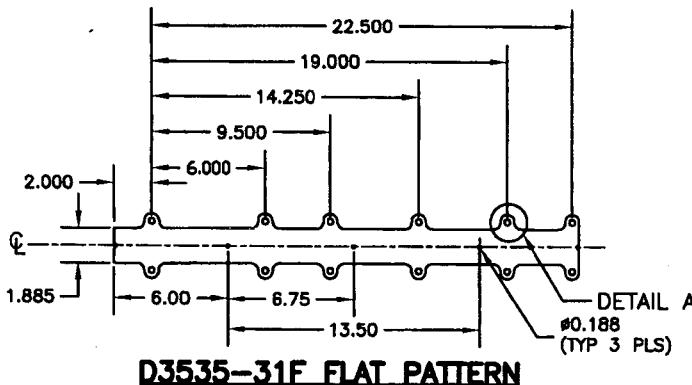
X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	16-9-8	Date:	10/01/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.16	New Issue	KJ	 

DART

DESIGN C.B	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 4 OF 7 SCALE 1:10



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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304520GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \AA
- 4) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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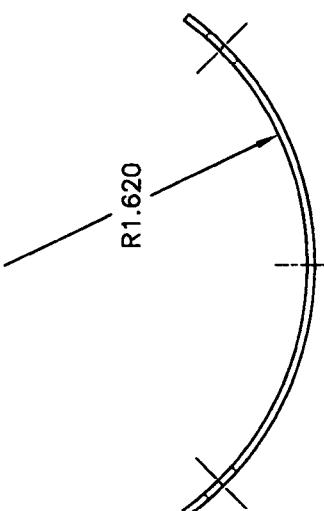
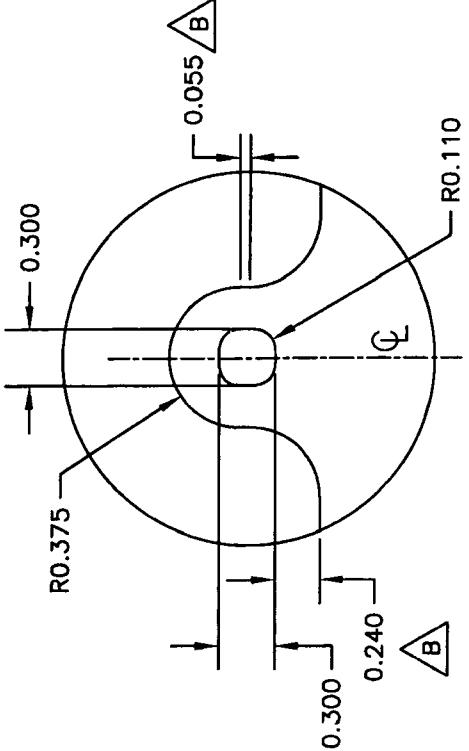
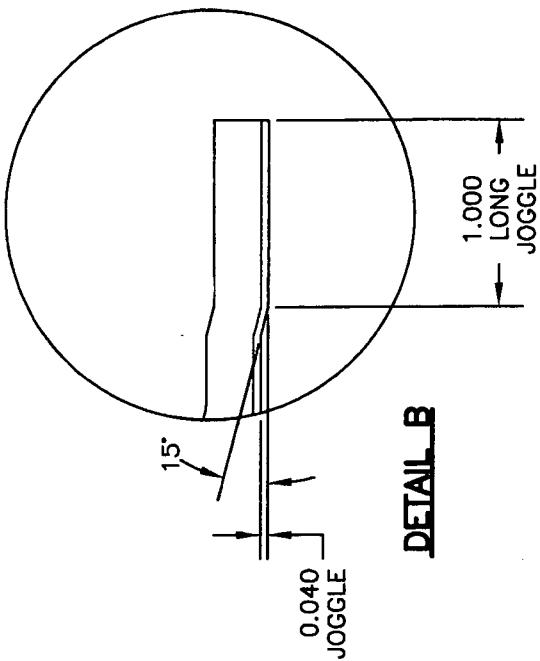
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DART

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE	SCALE 1:1

RELEASED

07.04.24 *[initials]**(61502)*
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